

Work Order ID 163402

Tuesday, June 27, 2017 11:37:49 AM

163402

Page 1

Item ID: D4771-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 7/10/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/17/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS Date: JUL 03 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: JUL 03 2017 SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4771	D

110 Weld per dwg A/R S.S. rod Batch: M134992 0.00***110***

Large Fab

Memo 1.28

Large Fab

1- Weld D4770-045 to wearplate as per dwg D4771

2- Transfer drill holes in bar

2 Q.L 17-08-15

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo 0.00

Quality Control

① 17-08-17 PD

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo 0.04

Quality Control

② 17-08-17 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

163402

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

2

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Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

140

140

Memo

APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005
(SEE NOTE 10 and 11 ON DWG)

150

Memo

QC5- Inspect part completeness to step on W/O

160

Memo

INDICATE FWD DIRECTION AS PER DWG
LOCATION : FP002

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																														

163402

Tuesday, June 27, 2017 11:37:49 AM

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89		AUG 18 2017	
170									
QC	Memo	0.20							
Quality Control							DAS 21 9-89	AUG 18 2017	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

Tuesday, June 27, 2017 11:37:47 AM

Work Order ID: 163402

163402

Parent Item: D4771-041

D4771-041

Parent Item Name: Wearplate Assembly

Start Date: 7/10/2017

Required Date: 7/17/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.13 DWG REV.B DD VERF:JLM IPP REV:C
17.04.17 AS PER DWG REV.D DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4770-045 *D4770-045* Bar Weldment		Manufactured	No		164964	110	Each	0.0000	1	2	**	Q.L	17-08-15
D4771-1 *D4771-1* Wearplate		Manufactured	No			110	Each	7.0000	1	2	**	Q.L	17-08-15

Location

WA001

144814

Loc Qty

7

7

Loc Code

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

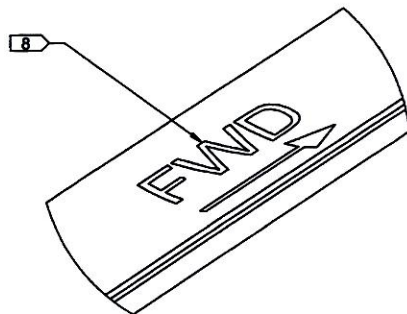
QA Closed: _____ Date: _____

Work Order update only ☐

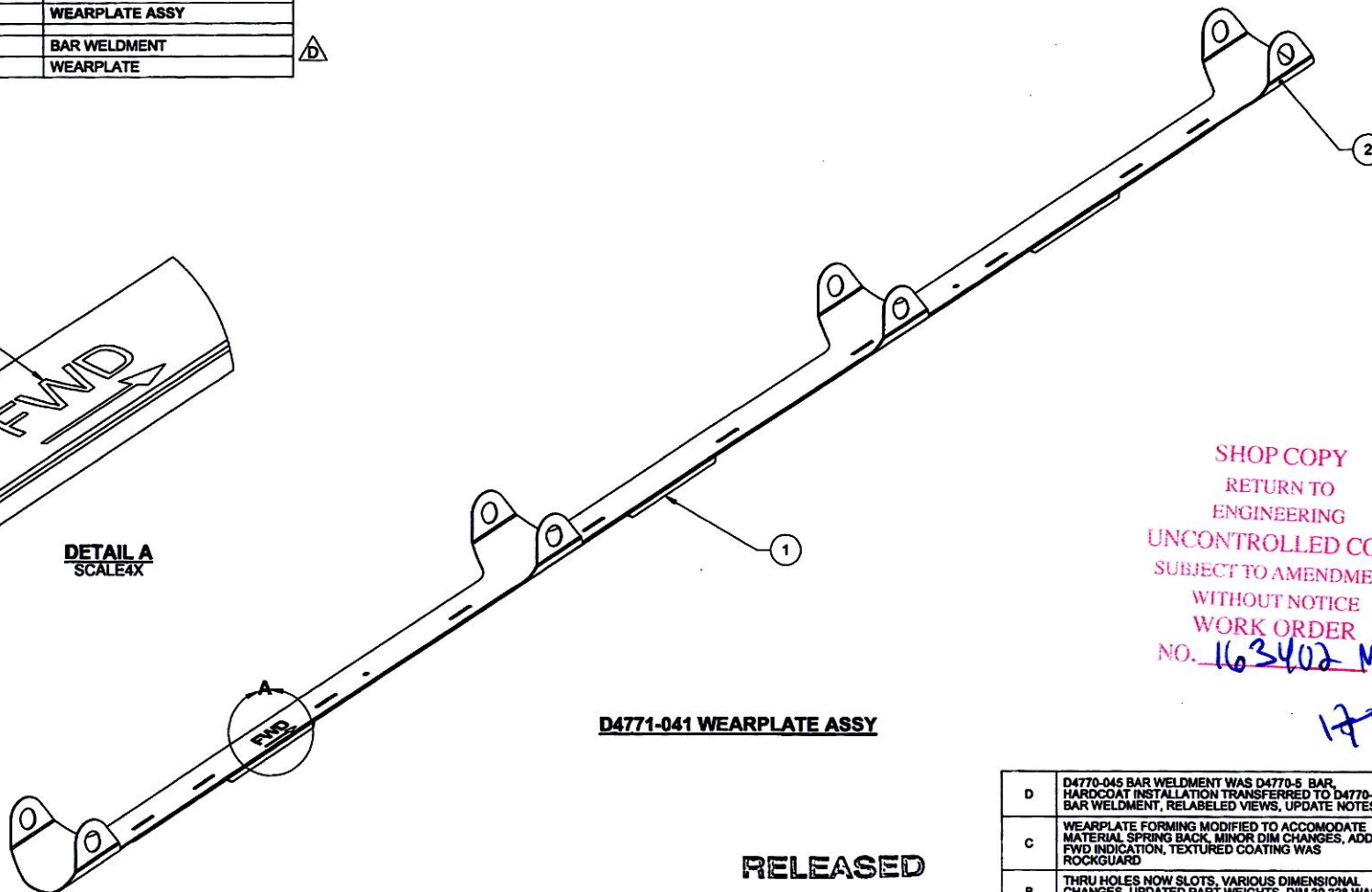
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY	P/N	DESCRIPTION
	X	D4771-041	WEARPLATE ASSY
1	1	D4770-045	BAR WELDMENT
2	1	D4771-1	WEARPLATE

△



DETAIL A
SCALE 4X



D4771-041 WEARPLATE ASSY

RELEASED

2017 APR 10
ECN 17-552

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 4.50 lbs
- 8) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163402 MJS
170703

D	D4770-045 BAR WELDMENT WAS D4770-5 BAR. HARDCOAT INSTALLATION TRANSFERRED TO D4770-045 BAR WELDMENT, RELABELED VIEWS, UPDATE NOTES	DB	16.04.14
C	WEARPLATE FORMING MODIFIED TO ACCOMMODATE MATERIAL SPRING BACK, MINOR DIM CHANGES, ADDED FWD INDICATION, TEXTURED COATING WAS ROCKGUARD	AP	15.04.01
B	THRU HOLES NOW SLOTS, VARIOUS DIMENSIONAL CHANGES, UPDATED PART WEIGHTS, DIM 39.328 WAS 41.876 (C3-3)	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D4771	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.04.14	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

